

Work Order ID 62060

Wednesday, September 15, 2010 1:49:15 PM



Page 1

Item ID: D2939-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 9/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

0.00

110



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

0.00

120



QC1- Inspect dimensions to dimension sheet

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 62060




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Item ID:	D2939-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle LH In, 206					
Start Date:	9/15/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	9/22/2010	Req'd Qty: 6.00		Customer:		

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 10/11/25		6	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		W 10/11/26		6	0		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951 Memo START TIME: 8:45 FINISH TIME: 9:15	0.00 0.00				6	BR 10-11-26		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62060

Wednesday, September 15, 2010 1:49:15 PM

Page 3

Item ID: D2939-1

Accept

Revision ID:

Item Name: Saddle LH In, 206

Setup Start

Stop

Start Date: 9/15/2010 Start Qty: 6.00

Required Date: 9/22/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 429

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 1:49:20 PM

Page 1

Work Order ID: 62060



Parent Item: D2939-1



Parent Item Name: Saddle LH In, 206


Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001  Saddle Billet		Manufactured	No			100	Each	23.0000	1	6			

Location

Loc Qty

Loc Code

MAT40

23

61385

23

B 63537 X6

MR 10/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>020640</i>
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.116	.113	.114	.112	Vern	ML-7
B	0.100	0.140		.113	.119	.114	.115		
C	0.100	0.140		.119	.118	.120	.120		
D	0.210	0.230		.219	.219	.218	.218		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.499	2.499	2.500		
H	0.510	0.515		.510	.510	.510	.511		
I	1.572	1.582		1.576	1.575	1.576	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.500		
K	0.257	0.262		.260	.260	.260	.260		
L	0.312	0.317		.314	.315	.314	.314		
M	0.235	0.240		.236	.236	.236	.236		
N	0.100	0.140		.115	.114	.113	.113	Mils	ML-2
O	0.540	0.560		.545	.550	.549	.550	Vern	ML-2
P	0.490	0.510		.497	.502	.500	.500		
Q	3.715	3.725		3.718	3.718	3.718	3.717		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.248	.249	.248	.248		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.628	1.629	1.628	1.628		
V	1.362	1.372		1.367	1.367	1.367	1.366		
W	0.316	0.321		.317	.317	.317	.317		
X	1.250	1.270		1.263	1.263	1.263	1.263		
Y	1.565	1.585	DT8695 A/B	1.576	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188	Rad-gage	REF
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>amf</i>
Date:	10/11/25

Audited by:	<i>H A</i>
Date:	10/11/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			2					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 62560
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

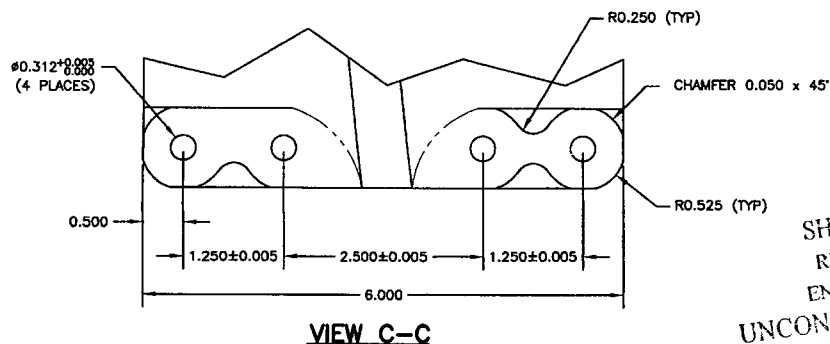
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.118	.112			Vern	ML-7
B	0.100	0.140		.117	.117				
C	0.100	0.140		.120	.120				
D	0.210	0.230		.218	.218				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.260	.260			Mick Vern	ML-1 ML-7
L	0.312	0.317		.315	.315				
M	0.235	0.240		.236	.237				
N	0.100	0.140		.112	.112				
O	0.540	0.560		.548	.549				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.718	3.718				
R	2.720	2.760		2.738	2.739				
S	0.240	0.270		.248	.248				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.627	1.628			Rad-gage	REF
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		.317	.317				
X	1.250	1.270		1.263	1.261				
Y	1.565	1.585	DT8695 A/B	1.575	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>Amf</i>
Date: 10/11/25

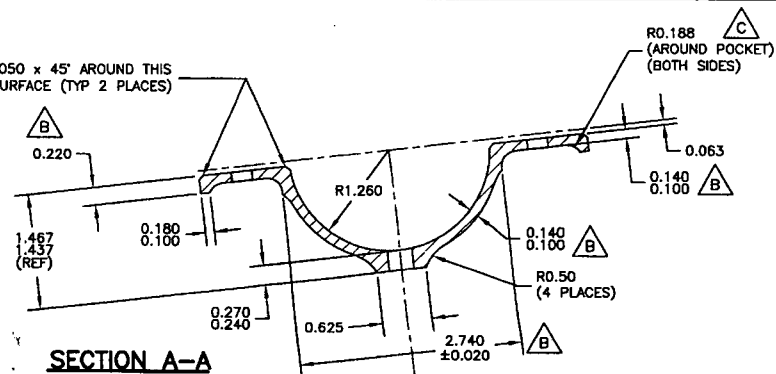
Audited by: <i>M.A</i>
Date: 10/11/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>Amf</i>



VIEW C-C

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)

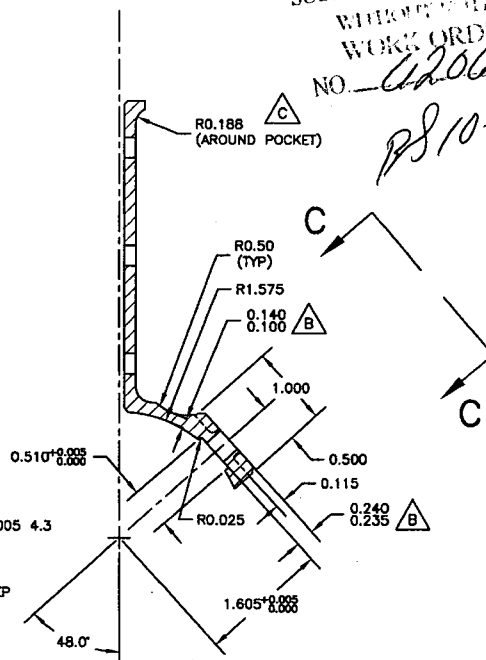


SECTION A-A

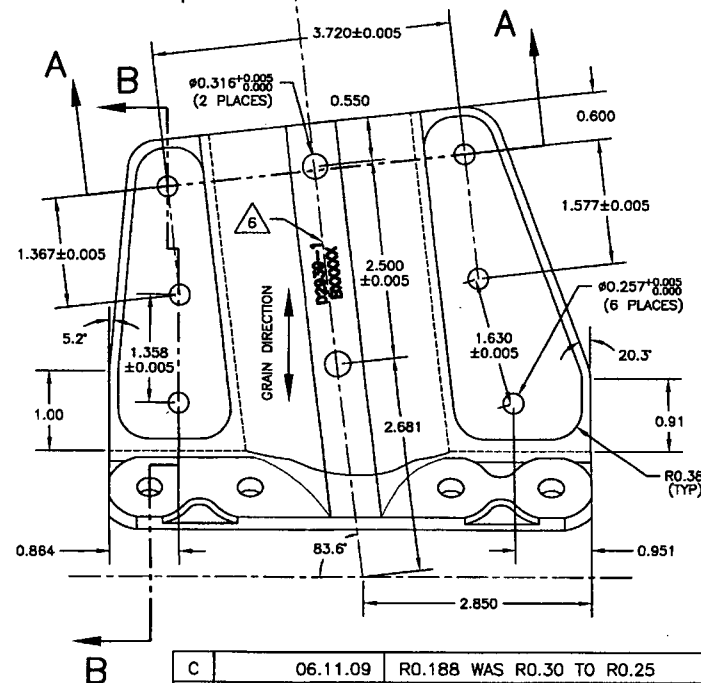
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT ORDER
WORK ORDER
NO. 42060
PS 10-9-15

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	<i>PH</i>	DRAWN BY <i>CB</i>
CHECKED	<i>PH</i>	APPROVED <i>CB</i>
DATE	06.11.09	TITLE SADDLE INSIDE
DRAWING NO. D2939		REV. C SHEET 1 OF 1
SCALE		2:3

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DART DART AEROSPACE USA, INC.
BELLEVUE, WA

01.02.12 *PH*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries